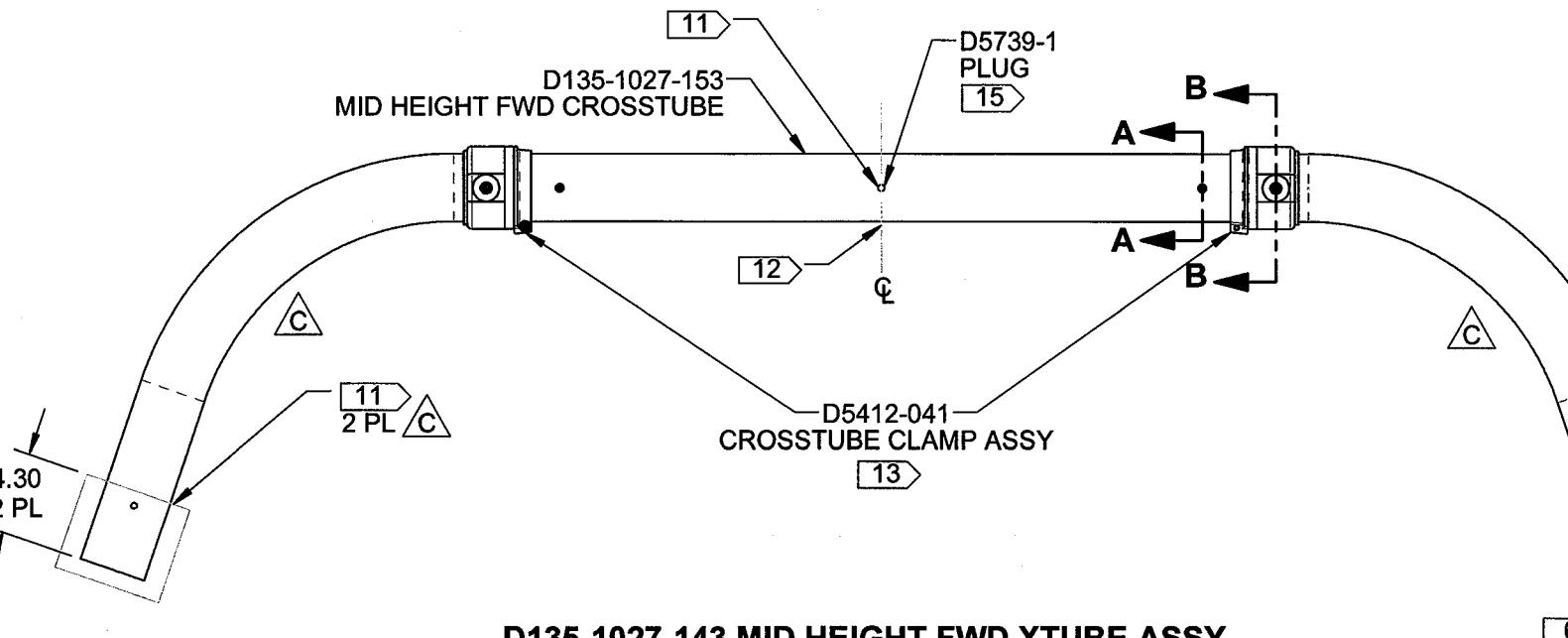
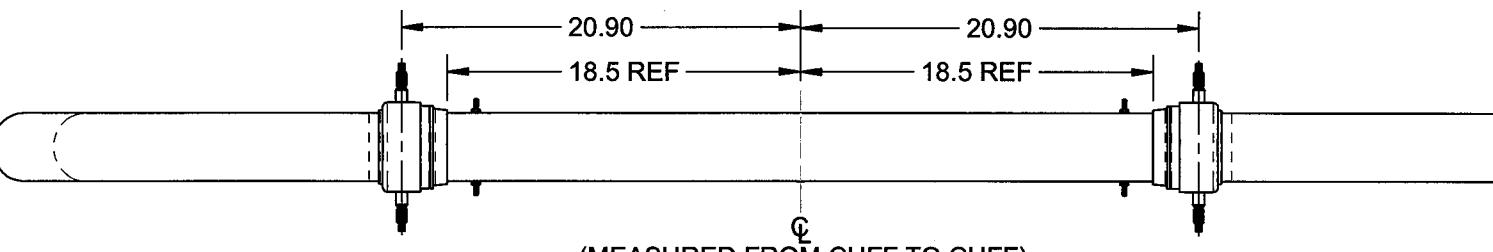
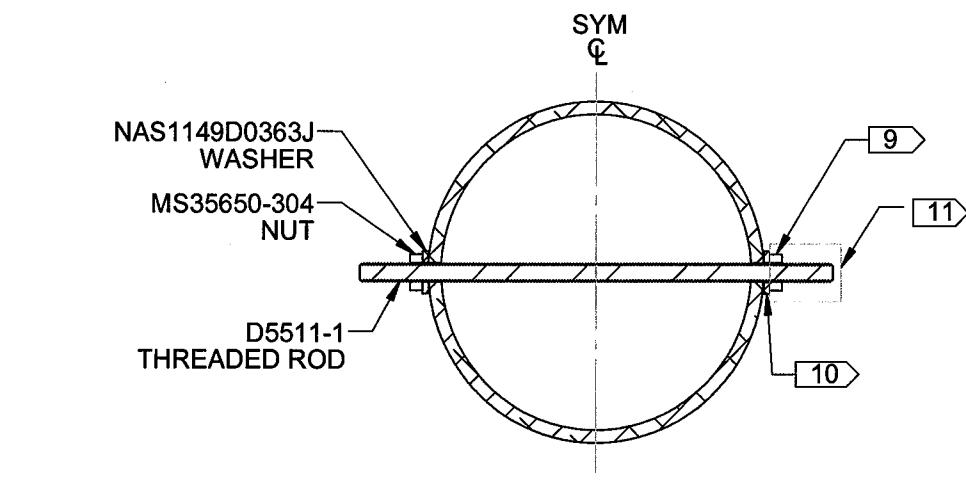
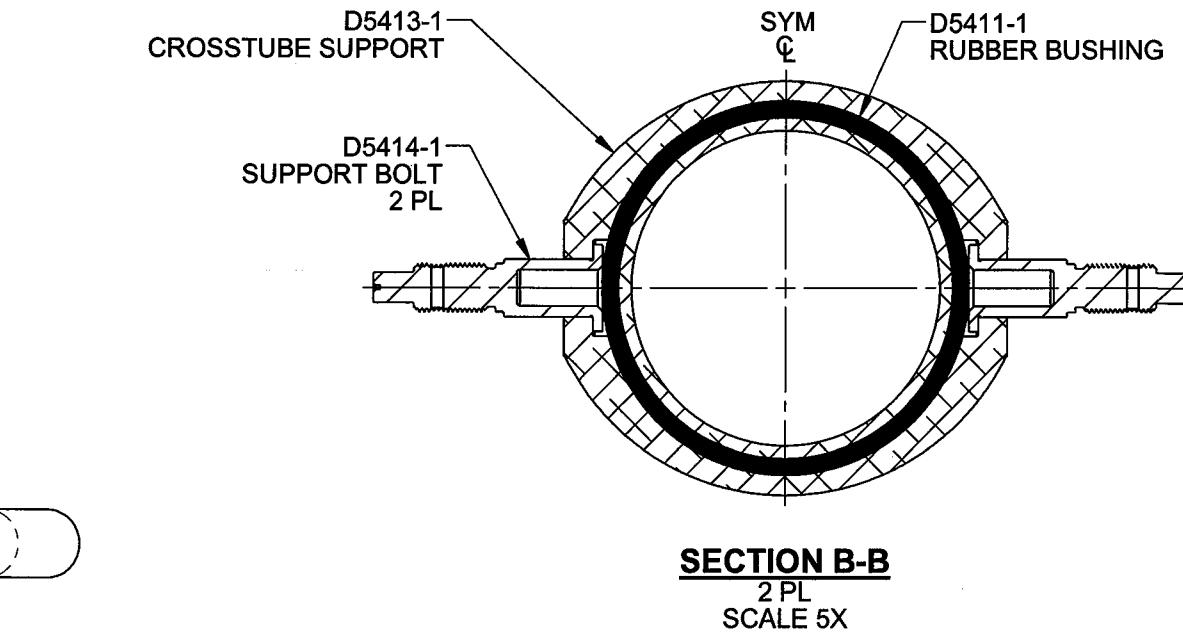


QTY -143	P/N	DESCRIPTION
X	D135-1027-143	MID HEIGHT FWD XTUBE ASSY
1	D135-1027-153	MID HEIGHT FWD CROSSTUBE
2	D5411-1	RUBBER BUSHING
2	D5412-041	CROSSTUBE CLAMP ASSY
2	D5413-1	CROSSTUBE SUPPORT
4	D5414-1	SUPPORT BOLT
2	D5511-1	THREADED ROD
1	D5739-1	PLUG
4	MS35650-304	NUT
4	NAS1149D0363J	WASHER

**D135-1027-143 MID HEIGHT FWD XTUBE ASSY**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT BARE TUBE PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PRIOR TO SUPPORT INSTALLATION PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)  
PAINT OUTSIDE PRIOR TO SUPPORT INSTALLATION PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N "D135-1027-143" AND B/N ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 18.40 LBS
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
- 9) PRIOR TO PRIME AND PAINT, APPLY 1 DROP OF LOCTITE 263 TO THE MATING THREADS OF D5511-1 IMMEDIATELY PRIOR TO  
INSTALLING AND TORQUING THE MS35650-304 NUT TO 5-10 IN-LBS
- 10) PRIOR TO PRIME AND PAINT, FILLET SEAL USING PR1422 B1/2 OR P/S-890 B1/2 SEALANT
- 11) MASK PRIOR TO PRIME AND PAINT
- 12) AFTER FINISHING MARK THE ENTIRE CIRCUMFERENCE OF THE CROSSTUBE CENTERLINE ( $\pm 0.1"$ ) PER QSI 044 6.1
- 13) PRESS D5412-041 CROSSTUBE CLAMP TIGHT AGAINST D5411-1 RUBBER BUSHING THEN TORQUE BOLT TO 50-70 IN-LBS
- 14) IT IS ACCEPTABLE TO USE MILD SOAP AND WATER OR A SMALL AMOUNT OF WATER BASED LUBRICANT TO INSTALL THE SUPPORTS
- 15) WET INSTALL D5739-1 PLUG USING PR1422 B1/2 OR P/S-890 B1/2 SEALANT

RELEASED  
2022 MAR 18 91  
HS ECR 366

APPROVED

D	REMOVE STEP HOLES, ECR 366	SAD	22.02.11
C	ADDED D5739-1, REVISED NOTES	MW	19.09.11
B	ADDED D5411-1, D5412-041, D5413-1, AND D5414-1 UPDATE NOTES, ADDED SECTION B-B	ZF	18.10.04
A	NEW ISSUE	AJS	17.07.10
REV.	DESCRIPTION		
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD	DRAWING NO. <b>D135-1027-143</b>	
CHECKED	RF	REV. D	
MFG. APPR.	FK	SHEET 1 OF 1	
APPROVED	CP	TITLE <b>MID HEIGHT FWD XTUBE ASSY</b>	
DE APPR.	CP 91	SCALE NTS	
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